

Date: Monday, 23/02/2009 3:30:32 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARMREST ASSEMBLY
<b>Job Number</b> : 46027	
<b>Estimate Number</b> : 13346	
<b>P.O. Number</b> :	<b>Part Number</b> : D3780041
<b>This Issue</b> : 23/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3780 REVC
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 44534	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/03/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Jul 09.02.24</u>	
<b>Comment</b> : Est Rev:A 08-05-26 new issue DD verified by:ec Est Rev:B 08-07-22 revB as per dwg verified by:EC Est Rev:C 09-01-08 rev.C as per dwg DD verified by:ec	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

(D3696041)

Arm Assembly



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Tube Assembly  
 batch: 46257

2.0

D3781041

Cushion Assembly



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Cushion Assembly  
 batch: B44535

3.0

D37853

Bracket



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Bracket  
 batch: 44540

4.0

AN96010L

Washer



**Comment:** Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)  
 Washer  
 batch: M1109032 M1101340

5.0

MS21042L3

Nut



**Comment:** Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)  
 Nut  
 batch: M110399

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 3:30:33 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST ASSEMBLY

Job Number: 46027

Part Number: D3780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS24693C273

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Screw

batch: M169962

SS 09/03/18 (24)

7.0

MS24693C277

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

batch: M169297

SS 09/03/18 (24)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D3780

\*\*\*\*torque screws as per dwg D3780\*\*\*\*

See w/o

B 58885 10-05-20

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker as per dwg (see note 6) and Stock

Location: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

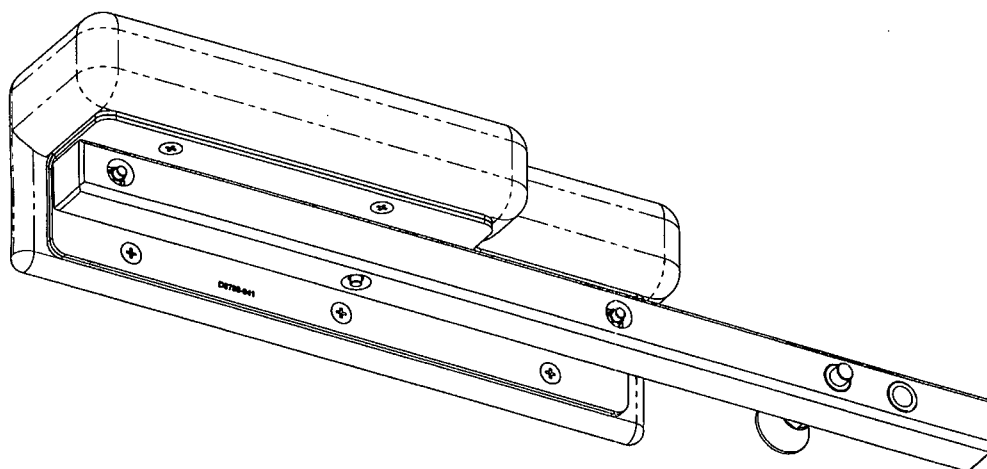
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	CUSHION ASSEMBLY
5	1	D3785-3	BRACKET
7	3	AN960JD10L	WASHER
8	3	MS21042L3	NUT
9	5	MS24693-C273	SCREW
10	3	MS24693-C277	SCREW

C



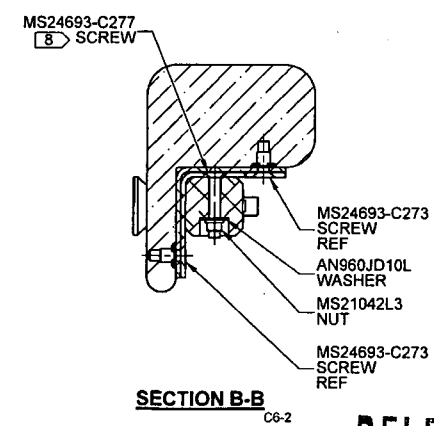
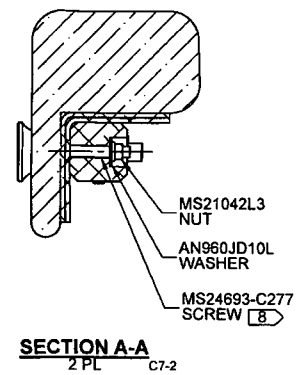
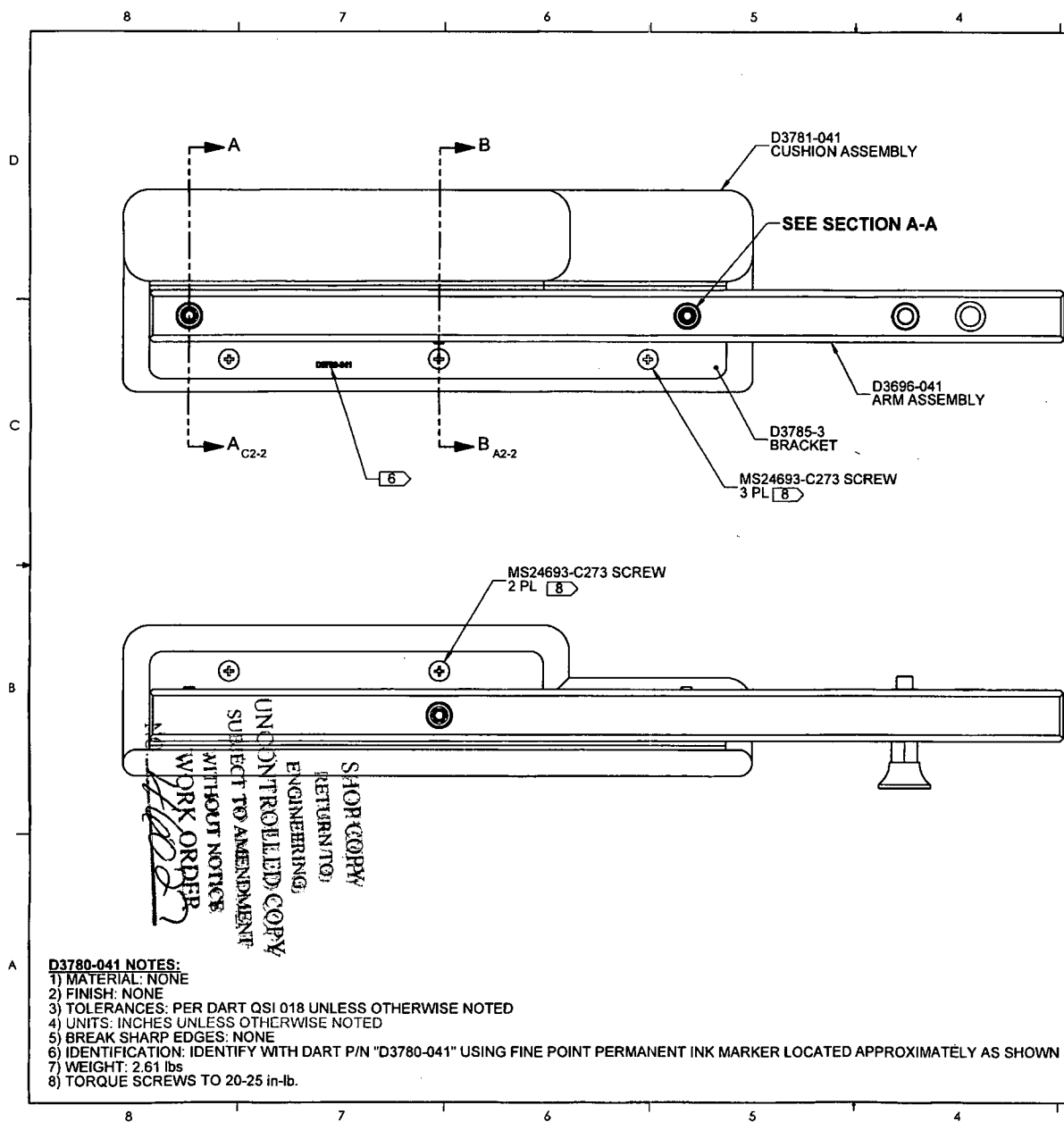
**D3780-041 ARMREST ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40027

RELEASED  
09/02/05

C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3780		REV. C SHEET 1 OF 2	
TITLE ARMREST ASSEMBLY		SCALE NTS	
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8 7 6 5 4 3 2 1



**D3780-041 NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 2.61 lbs
- 8) TORQUE SCREWS TO 20-25 in-lb.

SHOR COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 11003

**RELEASED**  
9/24/05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3780</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>ARMREST ASSEMBLY</b>	NTS
DATE	08.11.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Work Order ID 46027

June 26, 2009 11:49:57 AM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Armrest Assembly

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: 09/09/24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3780

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780\*\*\*\*torque screws as per dwg D3780\*\*\*\*

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Identify as per dwg & Stock Location: \_\_\_\_\_

Packaging

Memo

0.00

Packaging

51

**Work Order ID 46027**

June 26, 2009 11:49:57 AM



Page 2

Item ID: D3780-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Armrest Assembly

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D3781

150

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging



# Work Order ID 46027

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Page 3

Item ID: D3780-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Armrest Assembly

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

# Picklist Print

June 26, 2009 11:28:48 AM

Work Order ID: 46027

Parent Item: D3780-041RevC

Parent Item Name: Armrest Assembly

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960-10L 		Purchased	No				Each	0.0000	12.0000 			
Washer D3696-041RevB 		Manufactured	No				Each	0.0000	4.0000 			
Arm Assembly D3781-041RevC 		Manufactured	No				Each	0.0000	4.0000 			
Cushion Assembly D3785-3RevB 		Manufactured	No				Each	0.0000	4.0000 			
Bracket MS21042L3 		Purchased	No				Each	0.0000	12.0000 			
Nut MS24693-C273 		Purchased	No				Each	0.0000	20.0000 			
Screw MS24693-C277 		Purchased	No				Each	0.0000	12.0000 			